Document Number: 040-00072	Rev	Description	Date	ECO#
	1	SERVICE MANUAL	2/14/08	00239

Form Instructions

Title	**SERVICE MANUAL, TAIL LIGHT REPLACEMENT**
Operation Description	**Sub Assembly Removal and Replacement**

Standards	**Man Occup.**	**Machine Occup.**	**Cycle Time**	**Setup Time**	**Batch Qty**

Equipment List

Equipment	Manufacturer	Qty
1- Tail Light Assemblies L/R (Specify color(s) when ordering)	T3 Motion 024-00007 & -00008	1
2- Torx driver size T15	Any	1
3- Phillips screw driver	Any	1

Reference Docs	Document #	Description	Document #	Description
Related Files				
RESP ENGR	**Mark Jones**			

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Item#	Part #	Description	Qty
1	024-00007 & -00008	TAIL LIGHT R/L	1

Serious electrical shock can occur if precautions are not followed.

- **ALWAYS TURN OFF POWER BREAKER IN GLOVE BOX AND REMOVE POWER MODULES BEFORE PERFORMING ANY ELECTRICAL WORK.**

Power breaker in glove box

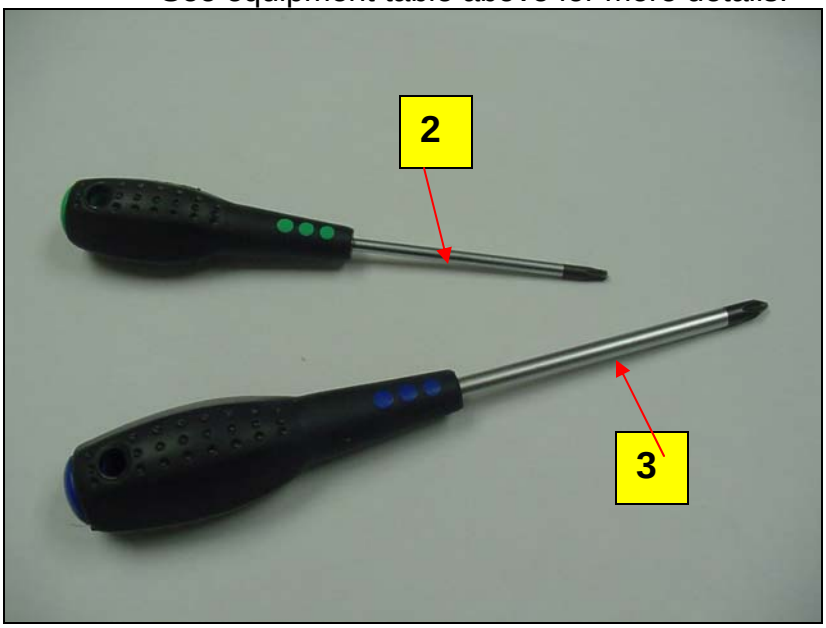
Power modules

- **ALSO SET THE PARKING BRAKE PRIOR TO ANY WORK.**

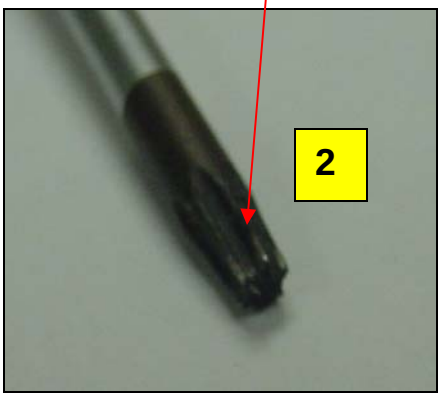
Parking brake

WORK INSTRUCTIONS:

1.0 Recommended tools for replacing the tail light assembly.
See equipment table above for more details.



Close up of Torx style driver.
Also commonly referred to as a star driver.



2.0 Tail Light assembly. (One complete set of left and right.)

3.0 Use the Torx driver to remove the two screws holding the tail light housing face and lens on.

4.0 The tail light housing face and lens will slide up and off of the tail light housing base, usually coming off in two pieces.

5.0 Lift out the LED and reflector assembly.

6.0 Release the clip and pull the connector apart.

NOTE: If you are only replacing the LED light and reflector assembly, proceed to step 10.0.

If you are also replacing the housing and or lens, continue with step 7.0.

7.0 Using the Phillips screw driver, remove the two screws holding the housing base to the fender. Use caution to not allow the wiring to fall into the fender once the housing base is removed.

8.0 These are the only parts that should have been removed. This is a right side set.

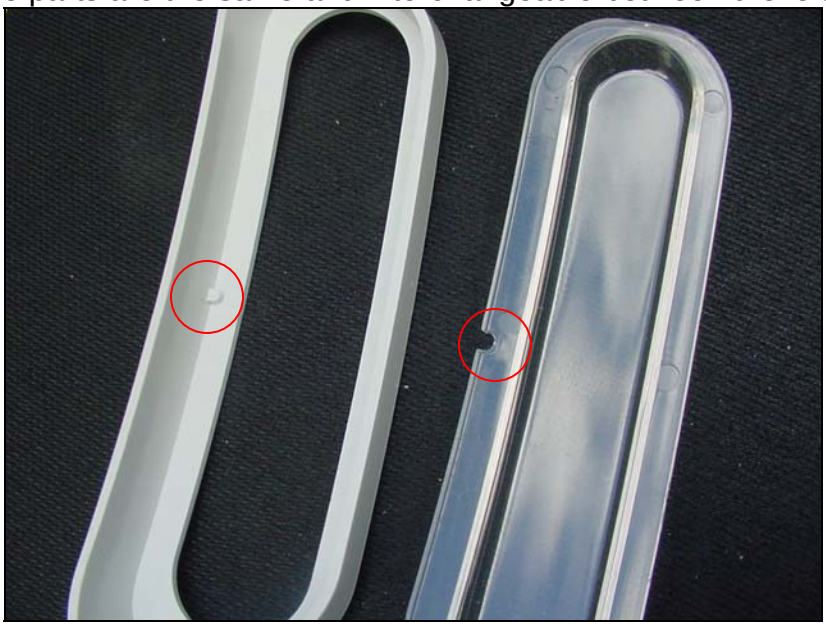
9.0 Install the new parts in the reverse order the old ones were removed. Mount the housing base with the two Phillips head screws. Be careful not to pinch the wiring between the housing base and the fender. Tighten screws until snug, do not over tighten.

10.0 Connect the plug of the new light. Note how the clip snaps over the locking tab.

11.0 Route the wiring as shown before inserting the LED and reflector assembly. Again, use care not to pinch the wiring when assembling.

Note that there is a left and a right LED/reflector part. Be sure to install them on the correct sides. This is the right side unit. Be sure to match the part to the picture. The light nacelles should point rearward, not upward.

12.0 Note the notch on the lens and corresponding tab inside the housing face. These parts are the same and interchangeable between the left and right sides.



13.0 Attach the housing face and lens assembly to the housing base with the Torx screws. Only tighten them until they are snug and there is no gap between the housing base and the housing face.

Finished installation of right and left side tail lights:

Right

Left

14.0 Test. 14.1 -Turn power breaker On.

14.2 -Set parking brake.

14.3 -Turn power key to On.

Make sure the brake lights work.

14.4 -Test the tail lights by turning on light switch and releasing the parking brake.

If the lights do not work, check the connections and check the battery charge levels.
If lights still do not work, contact T3 Motion at: (714)-619-3600